

**Work Order ID 72719**

Tuesday, August 09, 2011 4:30:55 PM



Page 1

Item ID: D3404-1

Accept



Setup Start



Revision ID:

Item Name: GHW Lug

Stop



Start Date: 8/9/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 8/10/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan: MWFDate: 11-08-09

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run-Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D3404

Rev C

100



BAND SAW

Bandsaw

Memo

Jeaspa Bandsaw

Cut blank: 2.750" long

*okf.k - 11/08/09 4 d*

110



HAAS CNC VERTICAL MACHINING #1

0.00

*B.A 11/08/11*

HAAS 1

HAAS CNC vertical machine #1

Memo

0.00

1-Machine as per Folio FA555 and Dwg D3404□Dwg Rev: C Folio Rev:  
AA □2-Deburr

*4 d*

120



QC2- Inspect parts off machine FAI/FAIB

0.00

*B.A 11/08/11*

QC

Quality Control

0.00

*4 d*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 72719**

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Item ID: D3404-1

Accept



Setup Start



Revision ID:

Item Name: GHW Lug

Stop



Start Date: 8/9/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 8/10/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop


**Sequence ID/  
Work Center ID**

130



QC

Quality Control

**Operation  
Description**

QC8- Inspect parts - second check

Set Up/  
Run Hours

0.00

SL 11-08-11

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

140



Packaging

Packaging

Identify as per dwg & Stock Location: WA

0.00

150



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

# Picklist Print

Tuesday, August 09, 2011 4:30:48 PM

Page 1

Work Order ID: 72719



Parent Item: D3404-1



Parent Item Name: GHW Lug

Start Date: 8/9/2011

Required Date: 8/10/2011

Start Qty: 4.00

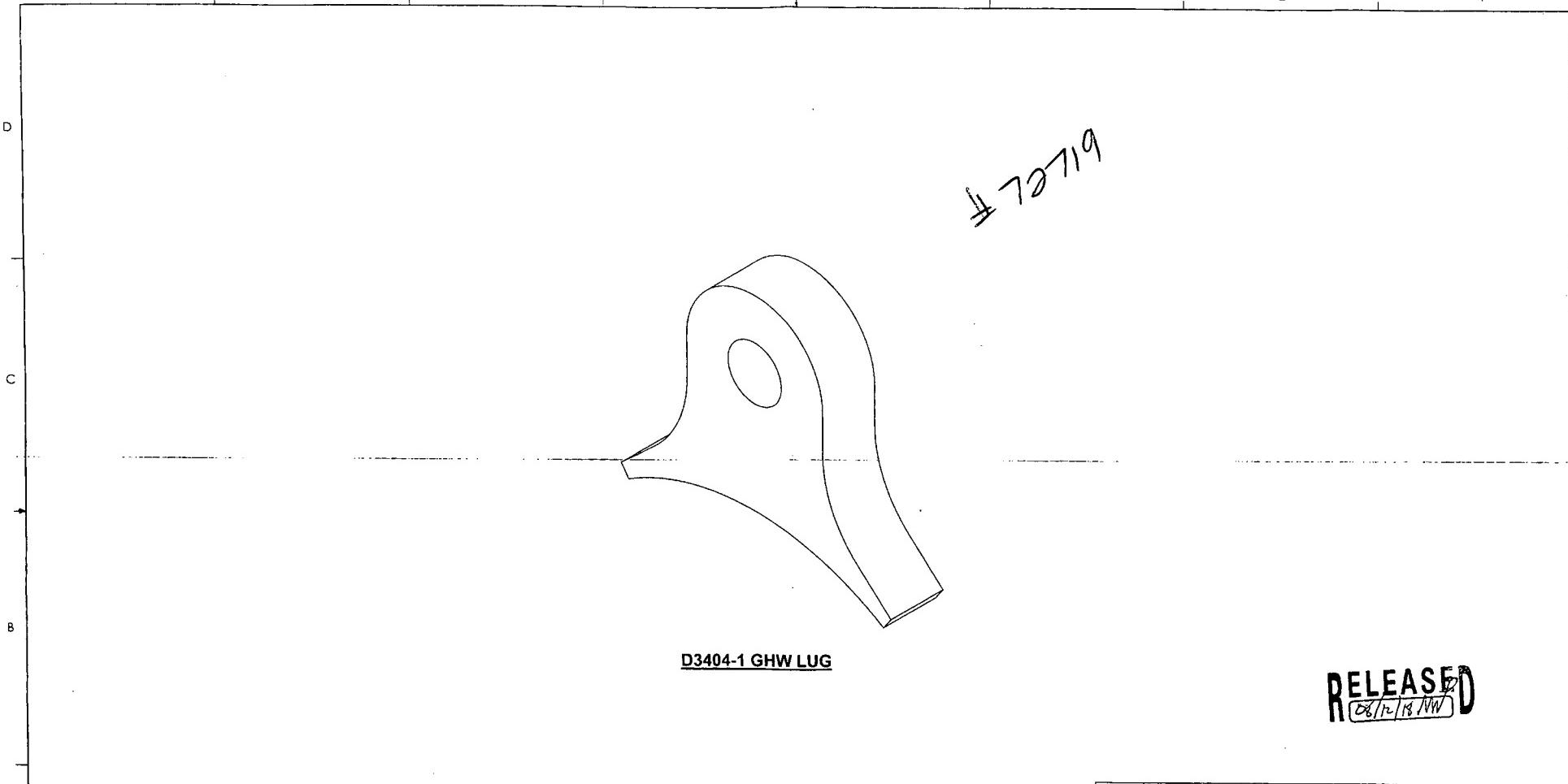
Required Qty: 4.00

Comments: IPP Rev:A□05.09.01□New issue□KJ/JLM□  
IPP rev B 09.01.28 new geometry rev.C EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304B0.750X2.500  304 BAR .750 X 2.50		Purchased	No			100	f	21.5360	0.2291	0.964632		FK - 11/08/09	

Location	Loc Qty	Loc Code
MAT050	21.536	
115869	10.8	
116765	10.736	09646

8 7 6 5 4 3 2 1



RELEASED  
08/12/13/NW

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL BAR  
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524  
REF. DART SPEC. M304B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.030 TO 0.060 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.34 lbs

8 7 6 5 4 3 2 1

C	DRAWING REDRAWN IN SOLIDWORKS WITH CURRENT STANDARDS AND TRANSFERRED TO "B" SIZE BORDER. B6-2, 2.30 RAD WAS 2.13. C7-2 1.14 DIM WAS 1.20.			AJS	08.12.02
B	UPDATE M-SPEC			PH	05.06.14
A	NEW ISSUE			PH	05.03.08
REV.	DESCRIPTION				BY DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			A
DRAWN	AJS	DRAWING NO.	D3404	REV. C	
CHECKED		MFG. APPR.		SHEET 1 OF 2	
APPROVED		DE APPR.		TITLE	SCALE
DATE	GHW LUG				
08.12.02	NTS				

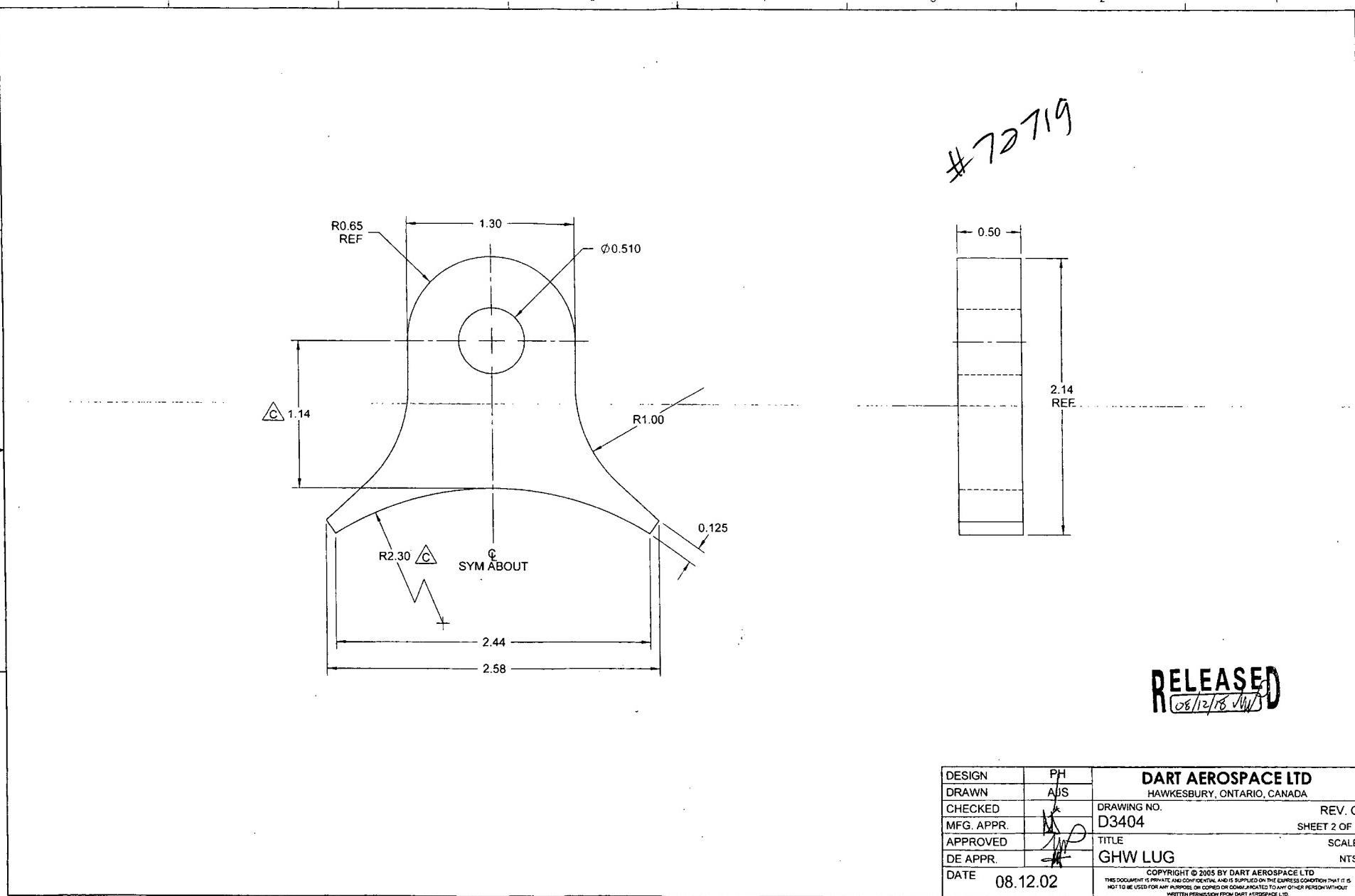
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DART AEROSPACE LTD	Work Order:	72719
Description: GHW Lug	Part Number:	D3404-1
Inspection Dwg: D3404	Rev: C	Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

Measured by:	<u>B.A</u>	Audited by:	<u>SL</u>	Prototype Approval:	N/A
Date:	11/08/11	Date:	11-08-11	Date:	N/A

<b>Rev</b>	<b>Date</b>	<b>Change</b>	<b>Revised by</b>	<b>Approved</b>
A	06.04.12	New Issue	KJ/JLM	
B	09.05.04	Dimensions updated per Dwg Rev. C	KJ/DD	

W/O:

## WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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